

Work Order ID 109364

109364

Page 1

November-21-13 7:48:56 AM

Item ID: D3531-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 11/21/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 2.00 *2*

Customer:

Reference: rework to Rev.B

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3531	B

125		0.00							
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125

Small Fab

Memo

0.00

Small Fab

PULL FROM STK:
2 X 3531-1 B86071
REWORK TO REV.B

140	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

140

QC

Memo

0.00

Quality Control

150	Chemical Conversion Coat per QSI005 4.1	0.00							
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150

HandFinish

Memo

0.00

Hand Finishing

TOUCH UP ALODINE

DAS
36
9-89

DAS
30
9-89

DAS
36
9-89

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Page 2

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00		DAS 30 9-89		2			11/11/21
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>G-A</u> Memo RE-IDENTIFY USING NEW B/N	0.00 0.00				2x			13/11/21
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/11/21

DAS
36
9-89

11/11-21

Picklist Print

November-21-13 7:48:56 AM

Page 1

Work Order ID: 109364

Parent Item: D3531-1

Parent Item Name: Bracket

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 2.00

Required Qty: 2.00

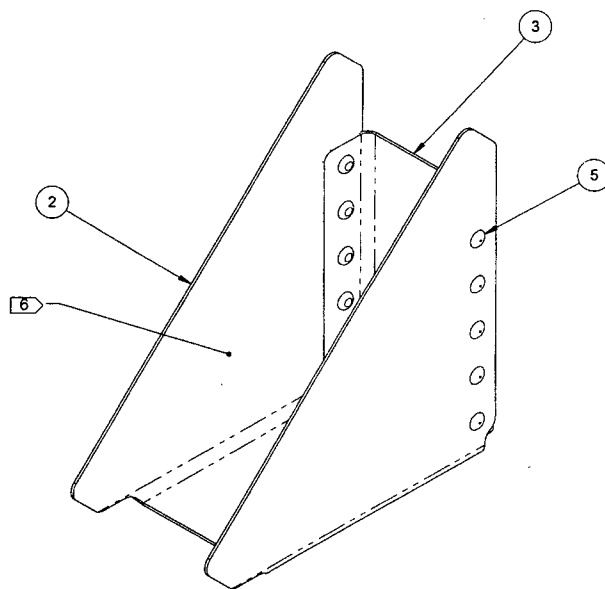
Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD
REV.B DD VERF:JLM

IPP REV:B 12.10.24 PER DWG

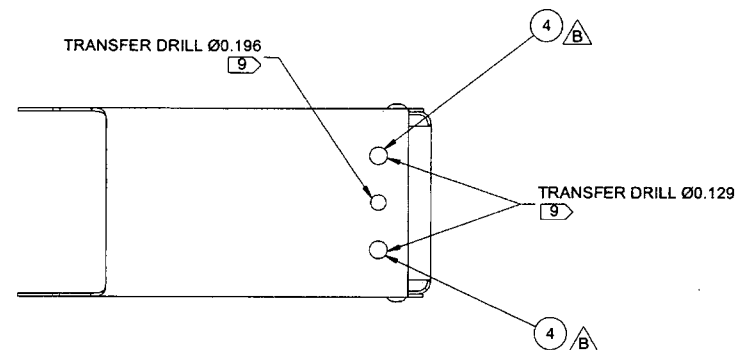
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 Bracket		Manufactured	No				Each	2.0000		2		13/11/21	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					<u>Loc Code</u>
				GA				2					
				96115				2					

86071 x 2

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3531-041	BRACKET ASSEMBLY
2	1	D3531-1	BRACKET
3	1	D3531-3	BRACKET FRONT PLATE
4	2	MS20426AD4-4	RIVET
5	10	MS20470AD4-4	RIVET



D3531-041 BRACKET ASSEMBLY



**D3531-041 BRACKET ASSEMBLY
BOTTOM VIEW**

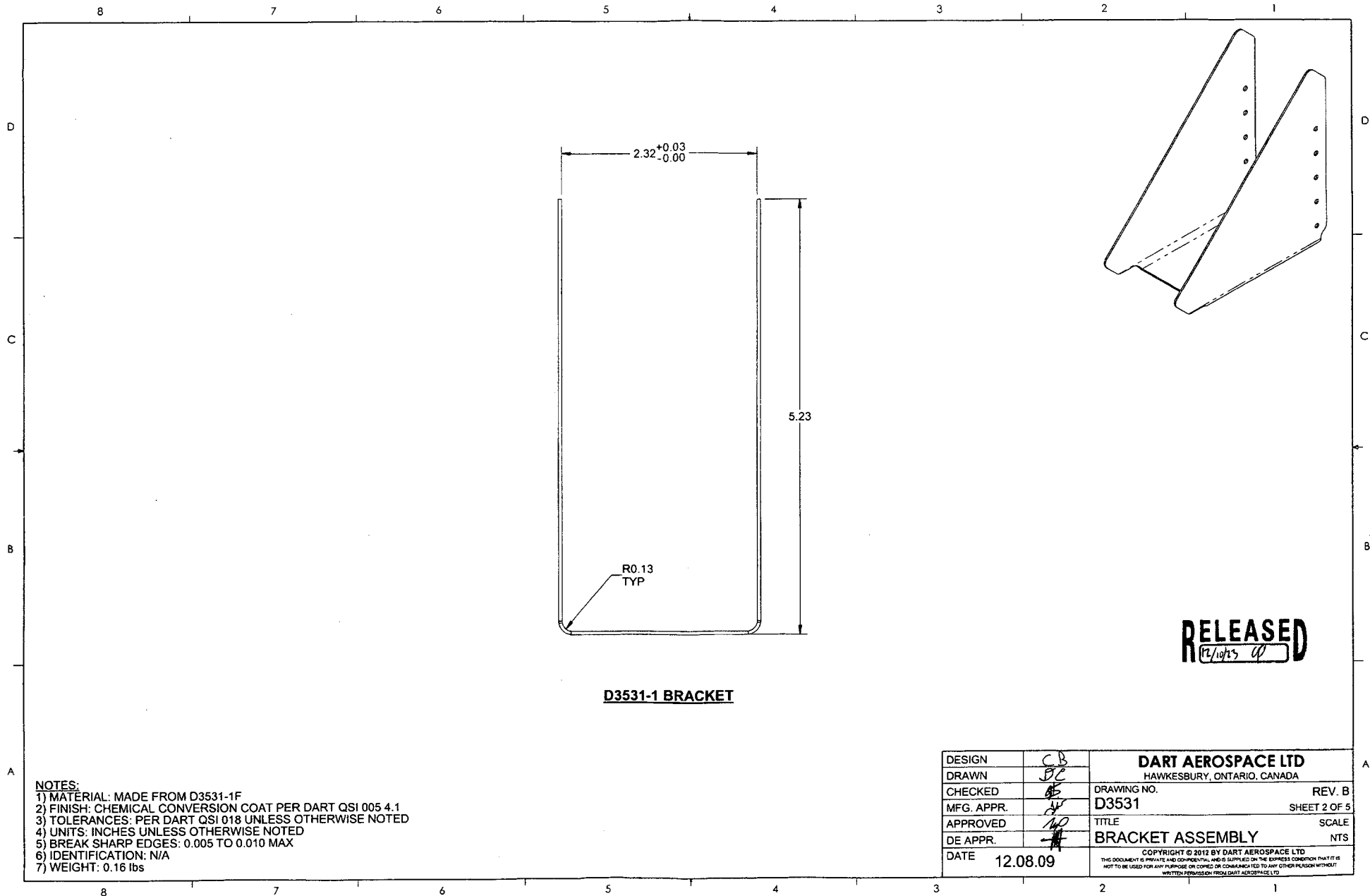
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
- 7) WEIGHT: 0.22 lbs
- 8) ASSEMBLE PER DART QSI 003
- 9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

W10109364

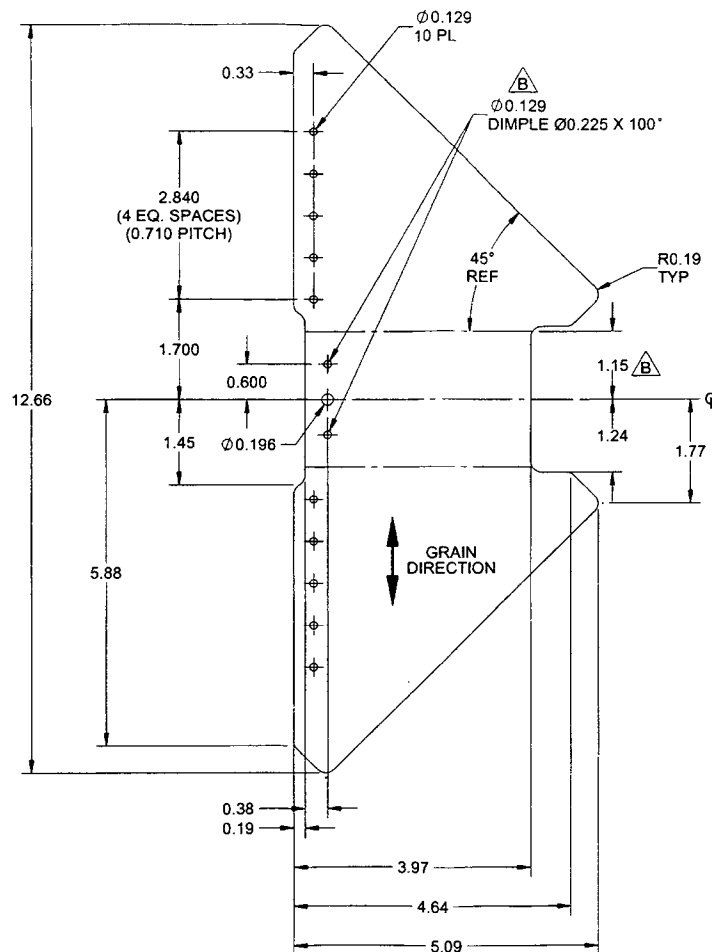
RELEASED
12/10/13 9'
PER ECU 12-669

B	CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3. ADD CSK, ZN C5-3. CORRECT BEND LINE DIM, ZN C4-3. UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47.	DC	12.08.09
A	NEW ISSUE	CB	07.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	DC		
CHECKED	CB		
MFG. APPR.	CB		
APPROVED	CB		
DE APPR.	CB		
DATE	12.08.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3531 REV. B SHEET 1 OF 5 TITLE BRACKET ASSEMBLY SCALE NTS <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



RELEASED
 12/10/15

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DRAWN	DC		
CHECKED	BE	DRAWING NO.	REV. B
MFG. APPR.	AV	D3531	SHEET 2 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	140	BRACKET ASSEMBLY	NTS
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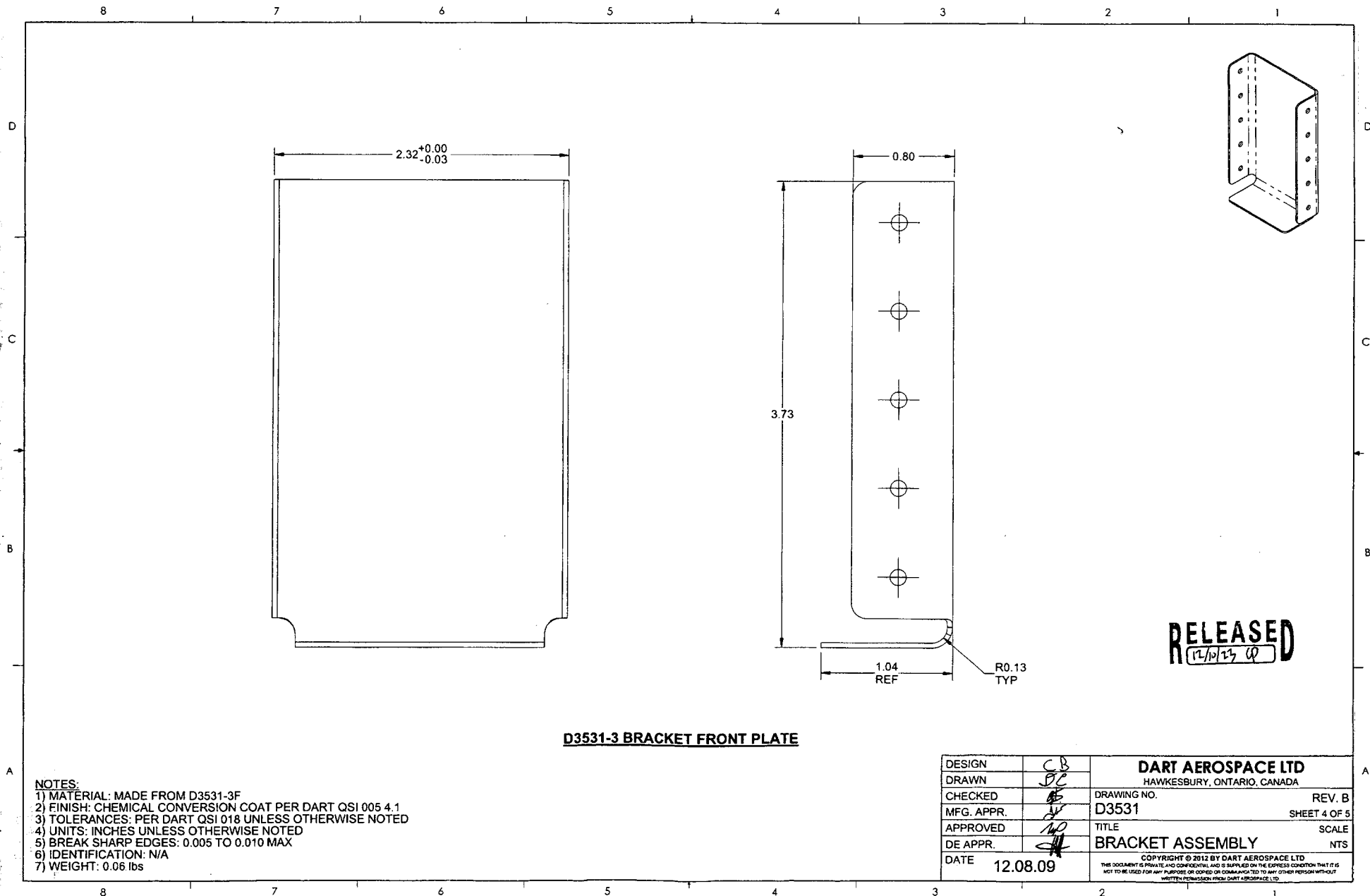
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

D3531-1F FLAT PATTERN

DESIGN	C.B.	DART AEROSPACE LTD	
DRAWN	J.C.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J.C.	DRAWING NO.	REV. B
MFG. APPR.	J.C.	D3531	SHEET 3 OF 5
APPROVED	J.C.	TITLE	SCALE
DE APPR.	J.C.	BRACKET ASSEMBLY	NTS
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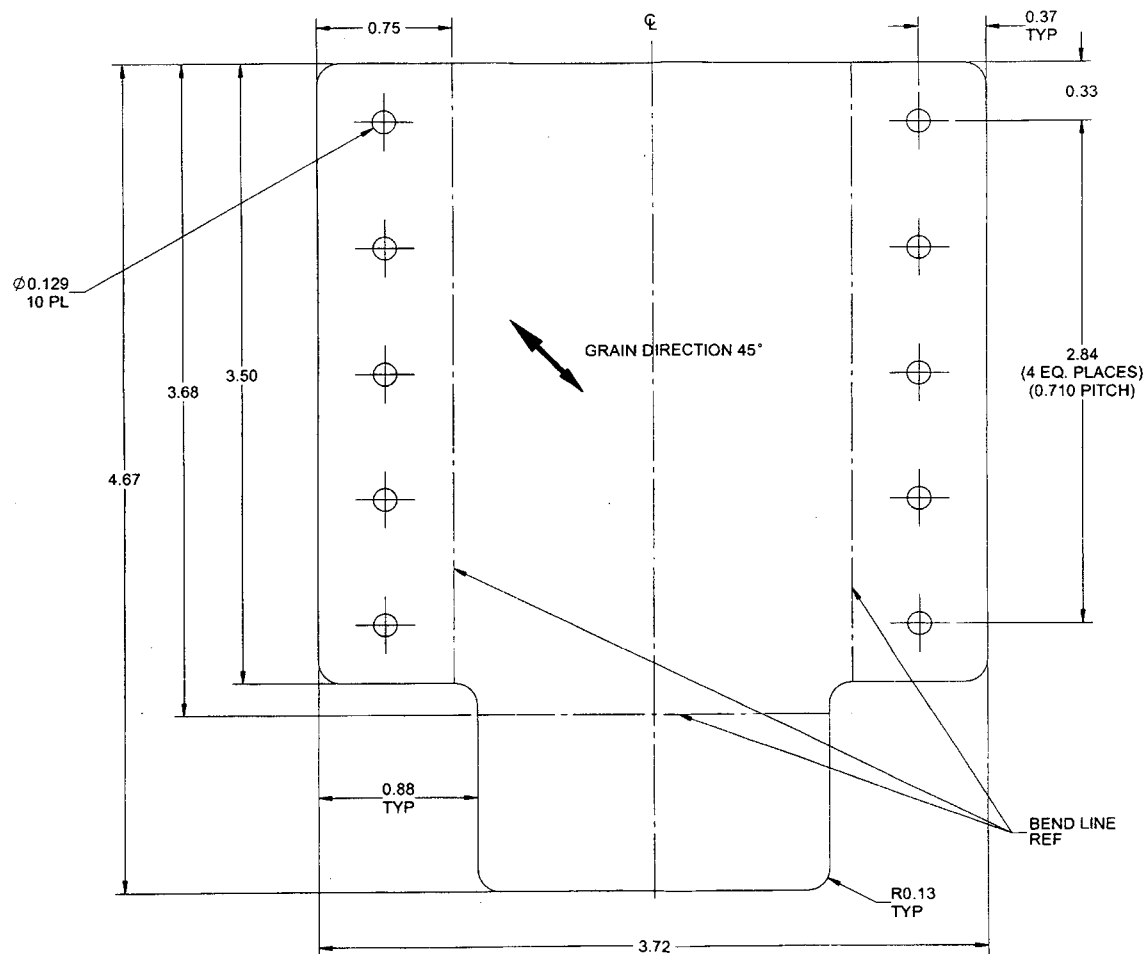
RELEASED
12/12/13



NOTES:

- 1) MATERIAL: MADE FROM D3531-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3531	SHEET 4 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BRACKET ASSEMBLY	NTS
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D3531-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. B
MFG. APPR.	AV	D3531	SHEET 5 OF 5
APPROVED	MA	TITLE	SCALE
DE APPR.	TH	BRACKET ASSEMBLY	
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11/10/13 AP